



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6205G09031-3G-PO

Job Sheet 184760



Part No: RBW6205G09031-3G-PO

Job Qty: 1 ea

Part Name: Main Rotor Head Support - Trolley Adapter



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/16/18

Job Tracking No:

Due Date: 12/17/18

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG RBW6205G09031-3G Rev.3 IPP Rev. A 18.10.16 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	3 1 pcs		12/17/18	0.00	0.00	Purchasing		DEC 18 2018
110	Packaging	1 pcs		12/17/18	0.00	0.00	Packaging2		DEC 18 2018
120	QC	1 pcs		12/17/18	0.00	0.00	QC6		
130	Packaging	1 pcs		12/17/18	0.00	0.00	Packaging3		
140	QC21-FG	1 Ea		12/17/18	0.00	0.00	QC21		DEC 19 2018

Part Op 100 - Issue P/O: 041306 MANUFACTURE RBW6205G09031-3G AS PER DWG Supplier: METEC Certificate of Descriptions: conformity is required

130 - The tool must be packaged with a desiccant bag into a tight fitting sealed plastic bag as per DWG.

oct 16. 2018 x 1 R h

GA181

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBW6205G09031-3GP	Main Rotor Head Support - Trolley Adapter	1 pcs (1 ea)	100-Purchasing	5138929

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBW6205G09031-3GP	1	0	0

Part Specifications

Specifications could not be found.

Plex 10/16/18 3:03 PM dart.Lussier.Patrick



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S138930



Part: RBW6205G09031-3G

Job No: 184760

Serial No/Batch: S138930

Revision: 3

Inspector:

Exp Date:

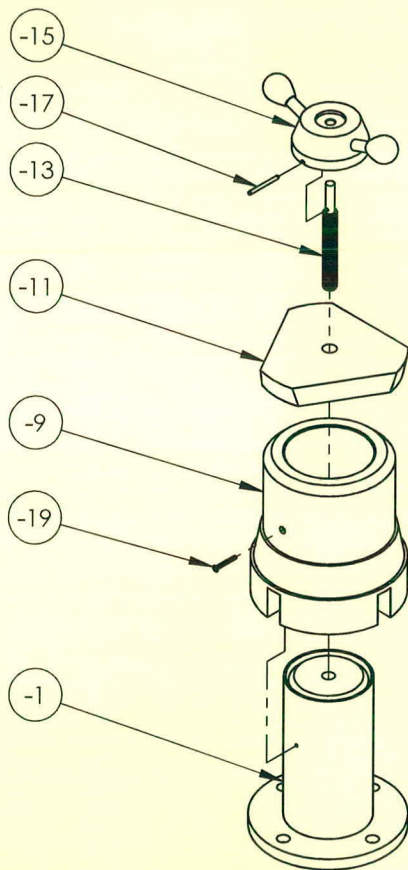
Instructions:

Date: 12/19/18

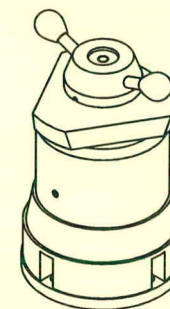
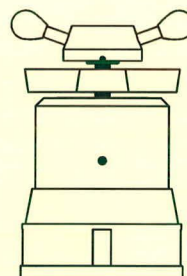
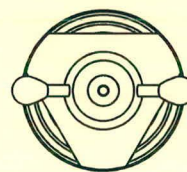
100

REC 10 2010
DEC 11 2010

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.



REVISIONS						
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED	
1		REDRAWN IN SOLIDWORKS. CH'D TOOL NUMBER WAS RBW6205G09031 IS RBW6205G09031-3G. CH'D DIM. PRECISION FROM .XXX TO .XX ON NON-CRITICAL PARTS. -1 CH'D FINISH WAS BLACK OXIDE IS BLACK ZINC. -3 CH'D O.D. WAS Ø3.430 S.F. -5 IS Ø3.500 S.F. -5 CH'D DIM. WAS Ø3.430 S.F. -3 IS Ø3.500 S.F. -3, REF. DIM. WAS Ø3.726 IS Ø3.797. -7 CH'D O.D. WAS Ø6.848 IS Ø7.00 CH'D B.C. WAS Ø5.375 IS Ø5.512 CH'D DIM WAS Ø3.758 IS S.F. Ø3.758. -9 CH'D HOLE WAS C-SINK Ø.41@100° ±.11 IS Ø.33 X 82° CH'D ENGRAVE NOTE WAS "T/N, S/N, AND MADE IN USA" IS "RBW6205G09031-3G-9" -11 ADDED DIMENSIONS 3X 2.50, (2X 60°), (3X 11°) CH'D ENGRAVE NOTE WAS "T/N, S/N, AND MADE IN USA" IS "RBW6205G09031-3G-9" -13 CH'D CALLOUT WAS Ø.394 S.F. -9 IS Ø.394 S.F. -15. -15 ADDED COUNTER BORE WAS Ø.159 THRU ALL IS Ø.159 ±.3.0 L Ø.201 ±.5. -15 ADDED ALTERNATE B/O# TO BOM IS ELSA CODE #65801.	8/21/2013	CFS	GE	
2		CH'D TITLEBLOCK WAS RED BARN IS DART. -1 ADDED HOLE AND LOCATION DIMS FOR 8-32 HOLE. -5 DELETED HOLE AND DIMS 8-32 ±.5, 4.777.	6/9/2014	DPD	GE	
3	15-0041	-13 CH'D FINISH WAS BLACK ZINC IS SILVER ZINC.	2/20/2015	RJC	JAG	



NOTE:

1. REF. AGUSTA T/N: 3G6205G09031.
2. TOOL USED W/ RBW6005G00131-3G.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-1	1	PIN WELDMENT			2
	1		-3		PIN TOP	1018		3
	1		-5		TUBE	STEEL DOM TUBING		4
	1		-7		BOTTOM RING	1018 RND BAR		5
			-9	1	COVER	DELIN TUBING		6
			-11	1	TOP	DELIN		7
			-13	1	THREADED ROD (HEX BOLT)	GR.5, PLATED	5/8-	8
			-15	1	TWO-ARM HAND WHEEL		(ELE	9
		B/O	-17	1	SLOTTED ROLL PIN	STEEL	Ø5/	1
		B/O	-19	1	FLAT HEAD SCREW	ZINC PLATED STEEL	82°	1
	ASSY -1							

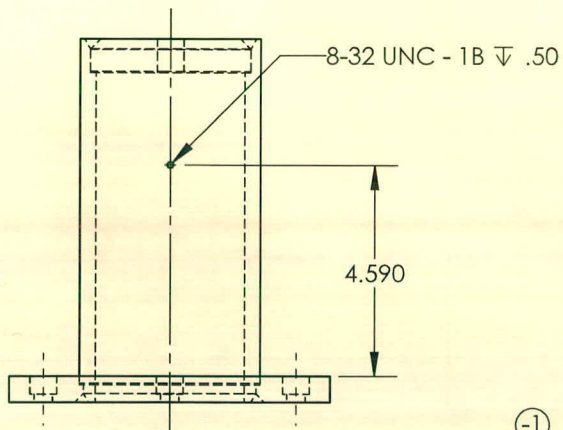
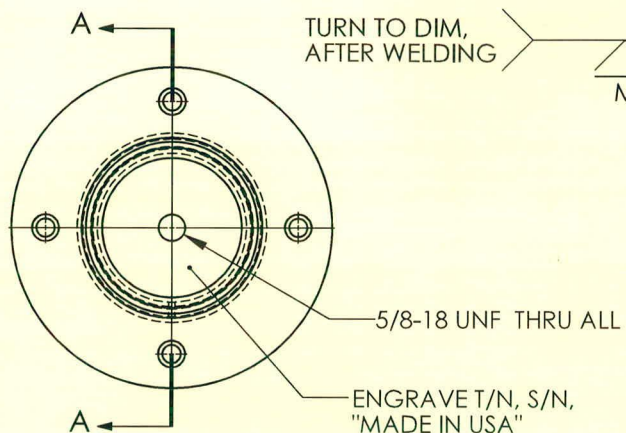
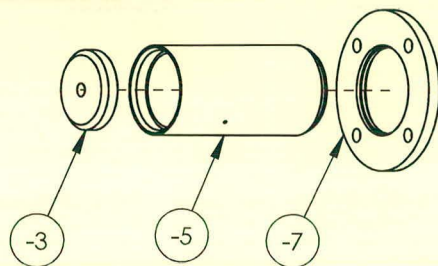
DART
AEROSPACE

TITLE		TROLLEY ADAPTER, M/R HEAD SUPPORT	
DWG NO.		RBW6205G09031-3G	
REV		3	
MAT'L		DRAWN BY: PERRITT	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		APPROVED <i>D Weil</i>	
.XXX ± .005 FRACTIONS ± 1/32		HEAT TREAT	
.XX ± .01 ANGLES ± 5°		FINISH	
.X ± .1		SPEC	
1. BREAK ALL SHARP EDGES .015 x 45°		USED ON MODEL	
OR .015R		AGUSTA	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING			
SCALE	1:8	DATE	4/23/2009
		SHEET 1 OF 9	

1 1430
9925

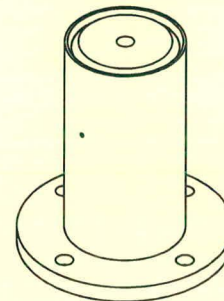
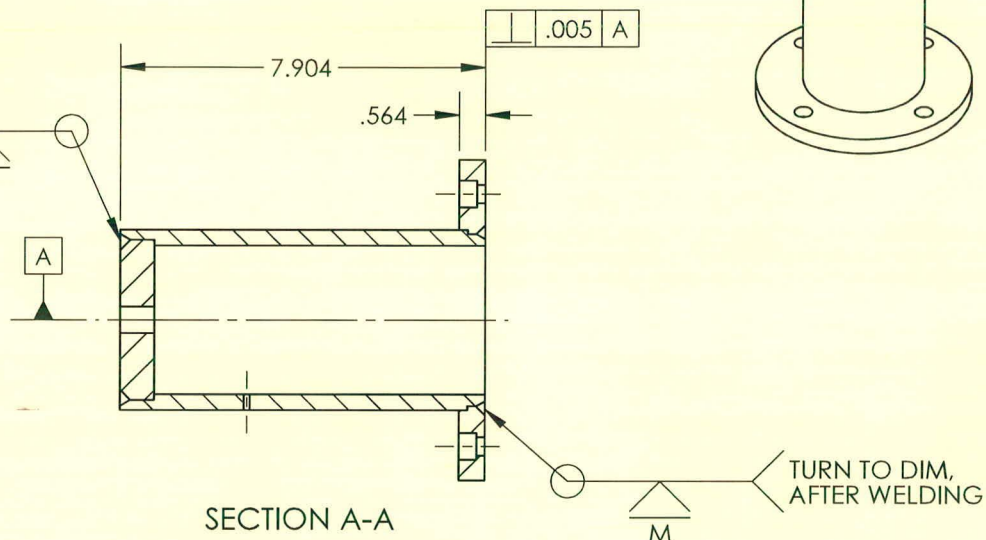
This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS			DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION			
1		-1 CH'D FINISH WAS BLACK OXIDE IS BLACK ZINC.	8/21/2013	CFS	GE
2		-1 ADDED HOLE AND LOCATION DIMS FOR 8-32 HOLE.	6/9/2014	DPD	GE



(-1)

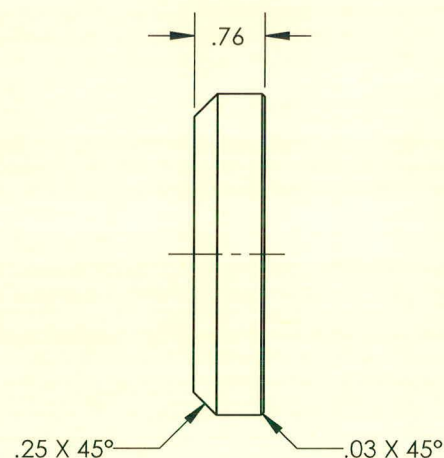
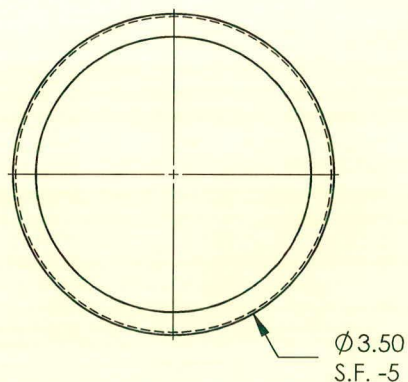
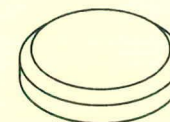
PIN WELDMENT



DART AEROSPACE	
TITLE TROLLEY ADAPTER, M/R HEAD SUPPORT	
DWG NO. RBW6205G09031-3G-1	REV 3
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± 5° .X ± .1	DRAWN BY: PERRITT APPROVED: <i>D Weil</i> HEAT TREAT FINISH BLACK ZINC SPEC ASTM B633-85, TYPE II, CLASS III USED ON MODEL AGUSTA
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:4	DATE 4/23/2009 SHEET 2 OF 9

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
1		-3 CH'D O.D. WAS Ø3.430 S.F. -5 IS Ø3.500 S.F. -5.	8/21/2013	

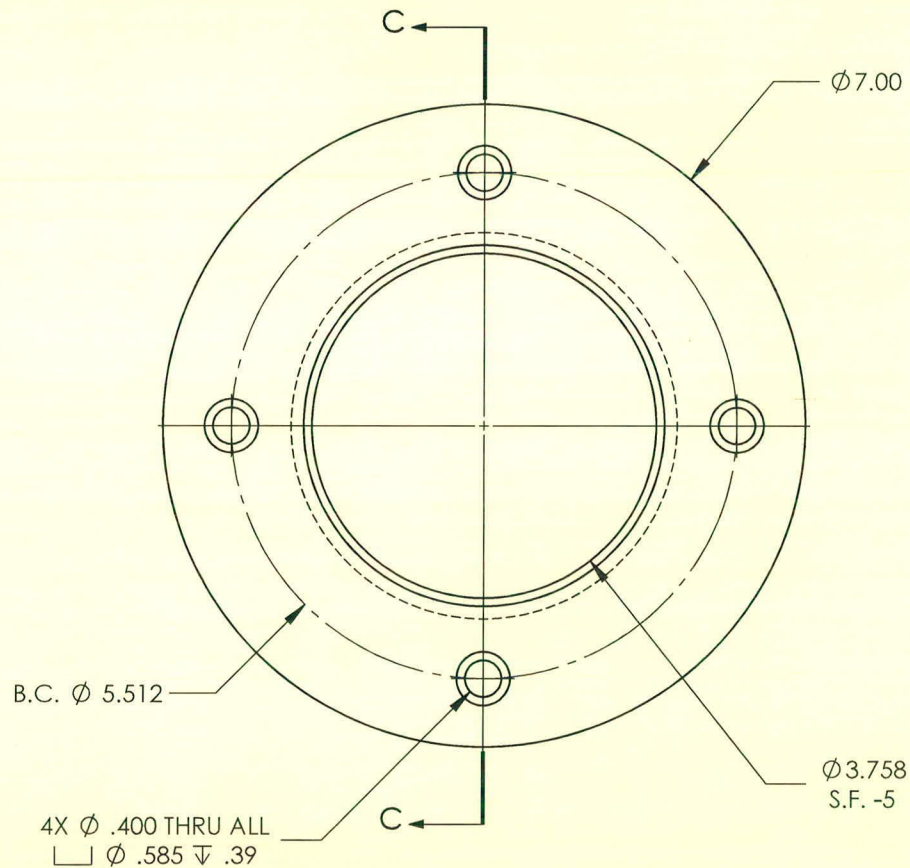


(-3)
PIN TOP

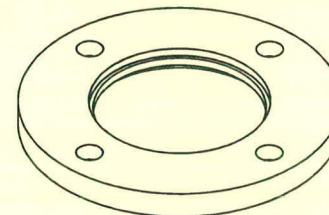
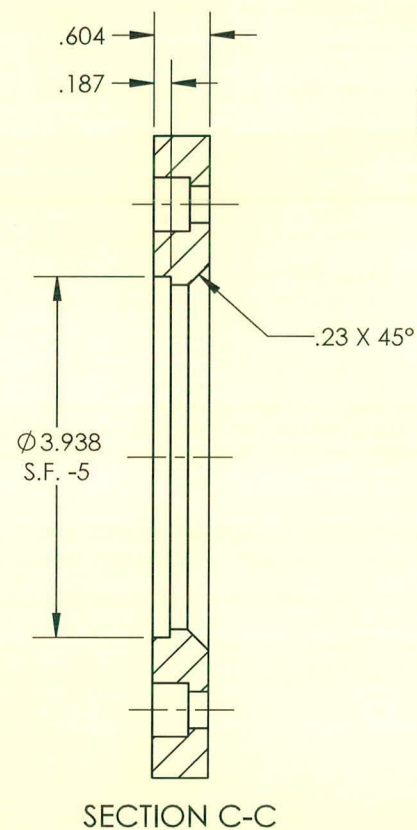
DART AEROSPACE	
TITLE TROLLEY ADAPTER, M/R HEAD SUPPORT	
DWG NO. RBW6205G09031-3G-3	REV 3
MAT'L 1018	DRAWN BY: PERRITT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005 FRACTIONS ± 1/32	HEAT
.XX ± .01 ANGLES ± 5°	TREAT
.X ± .1	FINISH SEE WELDMENT -1
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	SPEC
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL
	AGUSTA
SCALE 1:2	DATE 4/23/2009
	SHEET 3 OF 9

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS							
REV	ECR	DESCRIPTION			DATE	INITIAL	APPROVED
1		-7 CH'D O.D. WAS Ø6.848 IS Ø7.00 CH'D B.C. WAS Ø5.375 IS Ø5.512 CH'D DIM WAS Ø3.758 IS S.F. -5 Ø3.758.			8/21/2013	CFS	GE



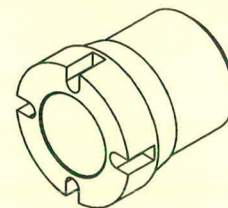
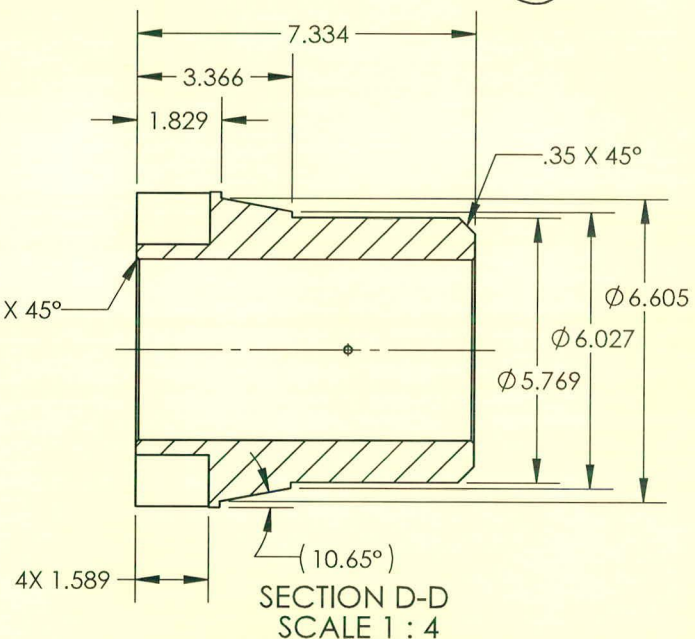
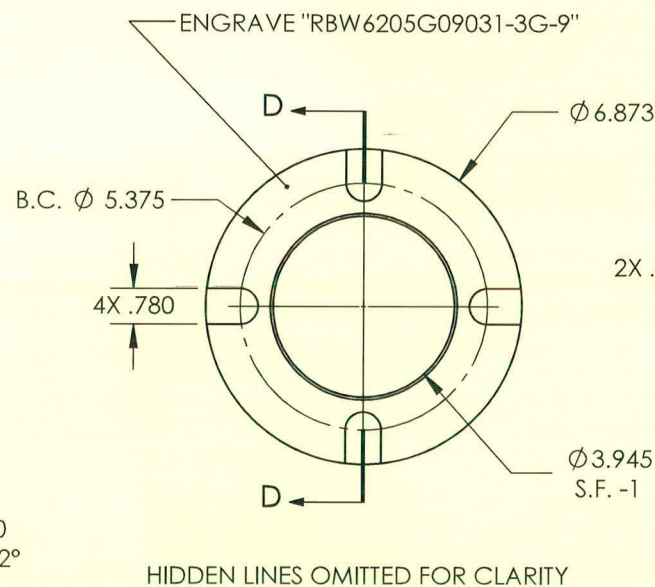
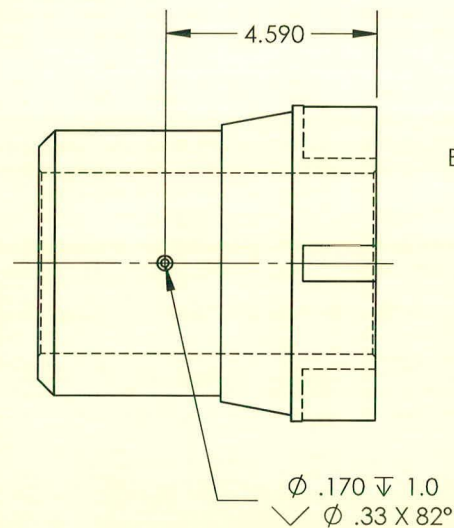
(-7)
BOTTOM RING



DART AEROSPACE	
TITLE TROLLEY ADAPTER, M/R HEAD SUPPORT	
DWG NO. RBW6205G09031-3G-7	REV 3
MAT'L 1018 RND BAR	DRAWN BY: PERRITT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005 FRACTIONS ± 1/32	HEAT TREAT
.XX ± .01 ANGLES ± .5°	FINISH SEE WELDMENT -1
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	AGUSTA
SCALE 1:2	DATE 4/23/2009
SHEET 5 OF 9	

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS			DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION			
1		-9 CH'D HOLE WAS C-SINK $\varnothing.41 @ 100^\circ \nabla.11$ IS $\nabla \varnothing.33 \times 82^\circ$ CH'D ENGRAVE NOTE WAS "TOOL No., SERIAL No., AND MADE IN USA" IS "RBW6205G09031-3G-9"	8/21/2013	CFS	GE

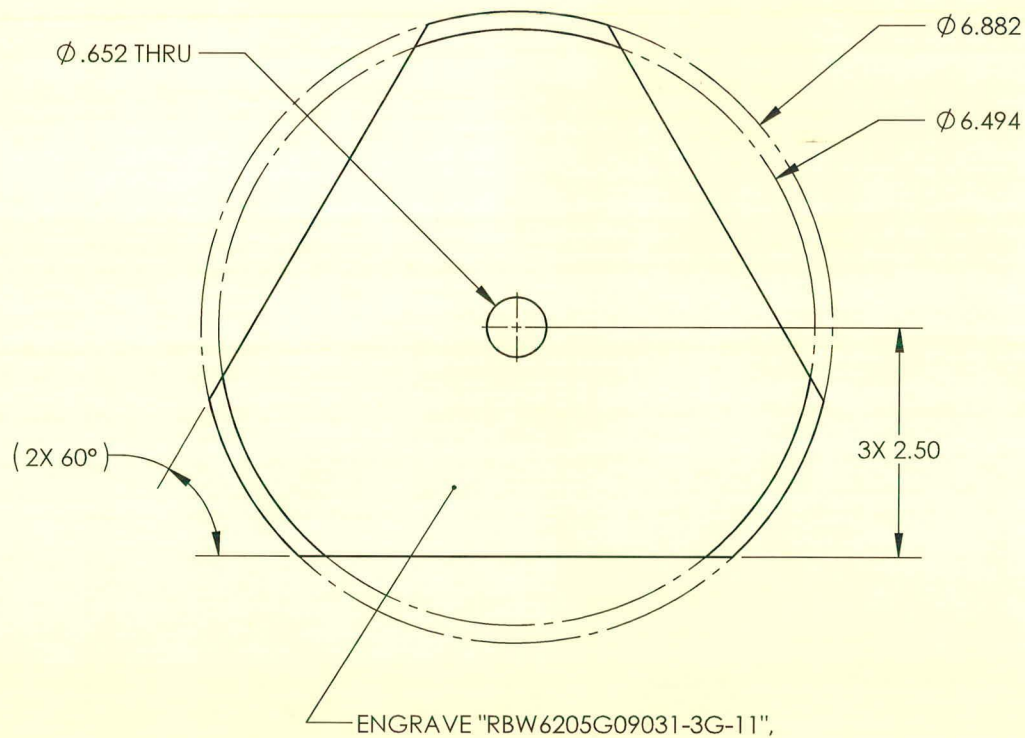


(-9)
COVER

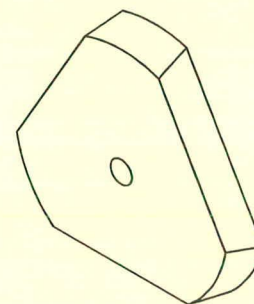
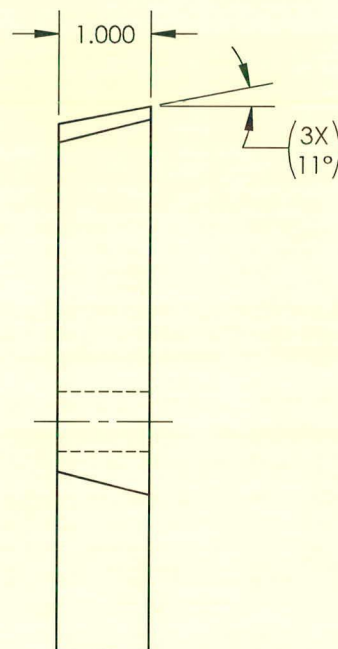
DART AEROSPACE	
TITLE TROLLEY ADAPTER, M/R HEAD SUPPORT	
DWG NO. RBW6205G09031-3G-9	REV 3
MAT'L DELTRIN TUBING	DRAWN BY: PERRITT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D. Weil</i>
.XXX ± .005	HEAT TREAT
.XX ± .01	FINISH
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	AGUSTA
SCALE 1:4	DATE 4/23/2009
SHEET 6 OF 9	

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS			DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION			
1		-11 ADDED DIMENSIONS 3X 2.50, (2X 60°), (3X 11°) CH'D ENGRAVE NOTE WAS "TOOL No., SERIAL No., AND MADE IN USA" IS "RBW6205G09031-3G-9"	8/21/2013	CFS	GE



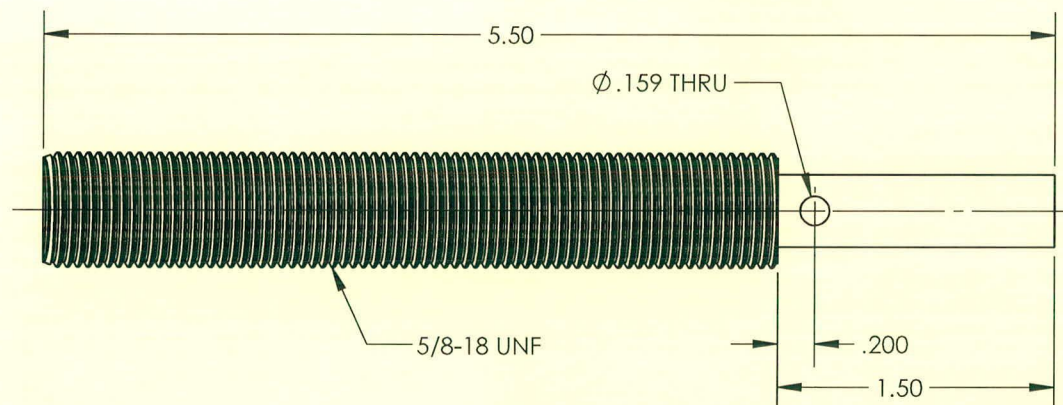
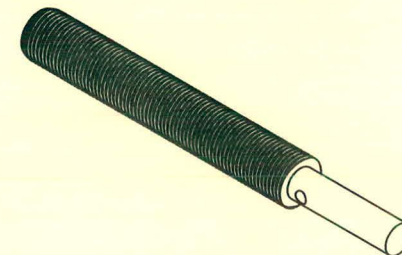
(-11)
TOP



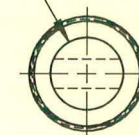
DART AEROSPACE	
TITLE TROLLEY ADAPTER, M/R HEAD SUPPORT	
DWG NO. RBW6205G09031-3G-11	REV 3
MAT'L DELRIN	DRAWN BY: PERRITT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005 FRACTIONS ± 1/32	HEAT
.XX ± .01 ANGLES ± 5°	TREAT
.X ± .1	FINISH
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	SPEC
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL
	AGUSTA
SCALE 1:2	DATE 4/23/2009 SHEET 7 OF 9

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
1		-13 CH'D CALLOUT WAS Ø.394 S.F. -9 IS Ø.394 S.F. -15.	8/21/2013	CFS
3	15-0041	-13 CH'D FINISH WAS BLACK ZINC IS SILVER ZINC.	2/20/2015	RJC



Ø.394
S.F. -15



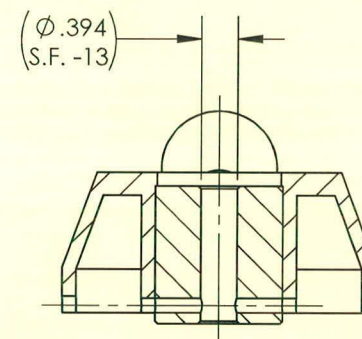
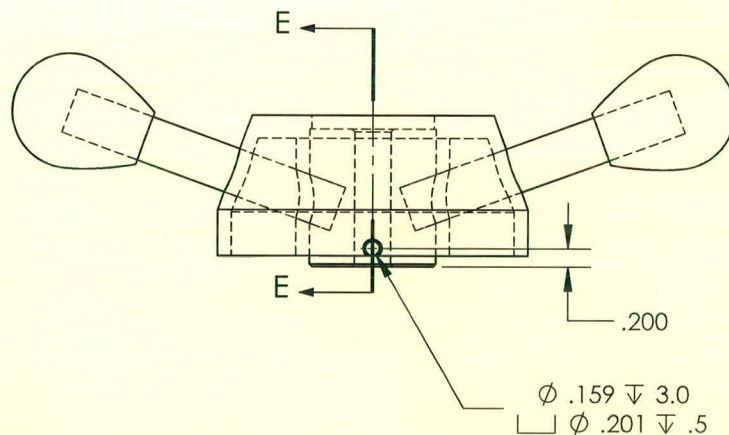
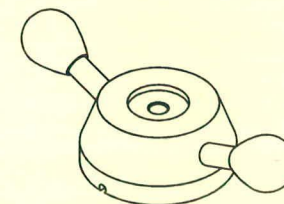
(-13)

THREADED ROD (HEX BOLT)

DART AEROSPACE	
TITLE TROLLEY ADAPTER, M/R HEAD SUPPORT	
DWG NO. RBW6205G09031-3G-13	REV 3
MAT'L GR.5, PLATED	DRAWN BY: PERRITT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005 .XX ± .01 .X ± .1	HEAT TREAT FINISH SILVER ZINC
FRACTIONS ± 1/32 ANGLES ± 5°	SPEC ASTM B633-85, TYPE II, CLASS III
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL AGUSTA
SCALE 1:1	DATE 4/23/2009
SHEET 8 OF 9	

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS			DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION			
1		-15 ADDED COUNTER BORE WAS Ø.159 THRU ALL IS Ø.159 ∇ 3.0 $\perp$ Ø.201 ∇ .5, -15, ADDED ALTERNATE B/O# TO BOM IS EELSA CODE #65801.	8/21/2013	CFS	GE



SECTION E-E

-15

TWO-ARM HAND WHEEL

DART AEROSPACE	
TITLE TROLLEY ADAPTER, M/R HEAD SUPPORT	
DWG NO. RBW6205G09031-3G-15	REV 3
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX $\pm$.005 .XX $\pm$.01 .X $\pm$.1 FRACTIONS $\pm$ 1/32 ANGLES $\pm$ 5°	DRAWN BY: PERRITT APPROVED: <i>D Weil</i> HEAT TREAT FINISH SPEC USED ON MODEL AGUSTA
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:2	DATE 4/23/2009
SHEET 9 OF 9	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041366**

Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO041366
PO Date: 10/16/18
Due Date: 12/17/18

Purchase Order
Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pynt Terms: Net 60

Freight Terms:

Special Comments:

Revision

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	184760	RBW6205G09031-3GP			Main Rotor Head Support - Trolley Adapter REV 3	Firmed	-	12/17/18	3 pcs	0 pcs	3 pcs	\$1,430.00/pcs	\$4,290.00

DEC 18 2018

DAE
38
9-89

Line Item Note SIOP

Grand Total: \$4,290.00

Order Notes

Procurement Quality Clauses
A005 RIGHT OF ENTRY
A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
A049 SUPPLIER AWARENESS

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 10/26/18 10:31 AM dart.Lussier.Patrick



METAL TECHNOLOGY INC.

www.metec.ca | 20 Terry Fox Drive, Vankleek Hill, Ontario, Canada K0B 1R0 | Phone: +1 613-678-3957 Fax: +1 613-678-3956

Packing List

Bill Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Ship Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Att. Patrick Lussier

Shipment No: 24411
Shipment Date: 19-Dec-2018
Ship Via: our truck
Order Number: 3095
Order Date: 10/17/18

Customer Code: DART
Phone: (613) 632-9577
PO Number: PO041366 ✓
Terms: Net 60 Days

----- Quantity -----								
<u>Item</u>	<u>Open</u>	<u>Shipped</u>	<u>B/O</u>	<u>Canceled</u>	<u>Unit</u>	<u>Description</u>	<u>Revision</u>	<u>Job Number</u>
2	3	3 ✓	0	0	EA	DART-RBW6205G09031-3GP Trolley Adapter, M/R Head Support	3	3095-01

DAT
38
9-89

The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.

Received In Good Order By
Att. Patrick Lussier



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

Quantity	Part Number	Part Name	Dwg Rev.#	P.O. Number
3 ✓	DART-RBW6205G09031- 3GP ✓	Trolley Adapter, M/R Head Support	3	41366 ✓

DAS
38
9-89

MATERIAL: supplied by METEC

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

George Theoret

Vankleek Hill, December 19, 2018

THE UNIVERSITY OF CHICAGO

LIBRARY OF THE UNIVERSITY OF CHICAGO

THE UNIVERSITY OF CHICAGO

LIBRARY OF THE UNIVERSITY OF CHICAGO

THE UNIVERSITY OF CHICAGO

LIBRARY OF THE UNIVERSITY OF CHICAGO

THE UNIVERSITY OF CHICAGO

LIBRARY OF THE UNIVERSITY OF CHICAGO

THE UNIVERSITY OF CHICAGO

LIBRARY OF THE UNIVERSITY OF CHICAGO